



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4798-041
Job Sheet 174989



Part No: D4798-041

Job Qty: 3 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/26/18

Job Tracking No:

Due Date: 4/4/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4798 REV.B IPP REV:A NEW ISSUE 13-03-26 JLM VERIFIED BY:DD IPP REV:B 13.05.28 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	4/3/18	4/3/18	0.00	0.00	Start Up Waterjet		SC 18/03/27
100	Waterjet	3 pcs	4/3/18	4/3/18	0.00	0.82	Waterjet1		SC 18/03/27
110	QC	3 pcs	4/3/18	4/3/18	0.00	0.00	QC2 Waterjet-1		SC 18/03/27
120	QC	3 pcs	4/3/18	4/3/18	0.00	0.00	QC8		38
130	Large Fab	3 pcs	4/4/18	4/4/18	0.00	9.59	Large Fab 8		9-47/8C
140	QC	3 pcs	4/4/18	4/4/18	0.00	0.00	QC5		10 18-3-27
150	QC	3 pcs	4/4/18	4/4/18	0.00	0.00	QC9		10 18-3-27
160	Packaging	3 pcs	4/4/18	4/4/18	0.00	0.00	Packaging3-2	JH605	APR 03 2018
170	QC21-SA	3 Ea	4/4/18	4/4/18	0.00	0.00	QC21		DAS 21 APR 03 2018

Part Op 100 - 1-Cut D4798-1 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 130 - ***USE DT9891 WELDING FIXTURE*** 1- Weld cups as per dwg A/R S.S. ROD BATCH: 9-80 Weld hard
 Facing as per dwg see note 9. 2059B hardcoat batch:
 140 - QC5- Inspect part completeness to step on W/O
 150 - QC9- Inspect visual per QSI004- Fusion Welds
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.4500 sf (1.15 ea)	90-Start up Operation	
D4379-1	Wearplate Cup	30 Ea (10 ea)	130-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	3	197	0
130-Large Fab	D4379-1	30	100	0

Part Specifications

Specifications could not be found.



Container No: S055684



Part: D4798 - 041

Job No: 174989

Serial No/Batch: S055684

Revision: B

Inspector:

Dart Aerospace Ltd.
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www.dartaerospace.com

Date: 03/27/18

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



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D5151-1
Job Sheet 174931



Part No: D5151-1

Job Qty: 20 ea

Part Name: Clamp Cushion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 14-12-17 JLM VERIFIED BY:DD IPP REV:B 15.01.19 DWG REV:PA1 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/17/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	20 pcs		4/18/18	0.00	0.52	Waterjet1		
110	QC	20 pcs		4/18/18	0.00	0.00	QC2 Waterjet-2		
120	QC	20 pcs		4/18/18	0.00	0.00	QC8-6		
130	Packaging	20 pcs		4/18/18	0.00	0.00	Packaging3		
140	QC21-SA	20 Ea		4/18/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MNEO60S.063	Neoprene Sheet 0.063	2 sf (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MNEO60S.063	2	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp Cushion	1.810Inches ± 0.030	1.840 1.780		
2	Clamp Cushion	2.000Inches ± 0.030	2.030 1.970		
3	Clamp Cushion	3.250Inches ± 0.030	3.280 3.220		
4	Clamp Cushion	4.000Inches ± 0.030	4.030 3.970		
5	Clamp Cushion	0.063Inches ± 0.010	0.073 0.053		

Plex 3/23/18 10:03 AM Dart.Gagnon.Michelle



Container No: S058137



Part: D5151-1

Job No: 174931

Serial No/Batch: S058137

Revision:

Inspector:

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Date: 04/04/18